

# Work Order ID 51924

Wednesday, September 09, 2009 11:35:42 A



Page 1

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 9/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

*BL*

Date: 09-9-09 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	Rev E								

100



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

*51924*

0.00

*LF 09/10/18*

Program Batch No. *51924* Double check by: *SL* ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and inspect

*6*

*0*

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

*ant 09/10/21*

Machine keyway as per dwg D2571 & D2572

*6*

*0*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*ant 09/10/21*

*6*

*0*

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Wednesday, September 09, 2009 11:35:42 A

Page 2

Item ID: D2571

Accept

Revision ID: E

Item Name: Saddle, Fwd Out 205

Start Date: 9/11/2009 Start Qty: 6.00

Required Date: 9/18/2009 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

MMW  
09/10/21

6

Ø

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

B/09-10-21

6

Ø

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

⇒ 24 09/10/22

26

Ø

Powder Coating

START TIME: 8:00am □ OVEN TEMPERATURE:  
8:30am □ FINISH TIME: 320°F

**Work Order ID 51924**

Wednesday, September 09, 2009 11:35:42 A



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 9/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

09-10-22



QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/10/23 6x 80

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-10-27

WF 09-10-24

# Picklist Print

Page 1

Wednesday, September 09, 2009 11:35:51 AM

Work Order ID: 51924



Parent Item: D2571RevE



Parent Item Name: Saddle, Fwd Out 205

Start Date: 9/11/2009

Required Date: 9/18/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB		Manufactured	No			100	Each	0.0000	6.0000			



Saddle Billet

Batch # B46412 ml 09/10/20 6

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 57924

RELEASED

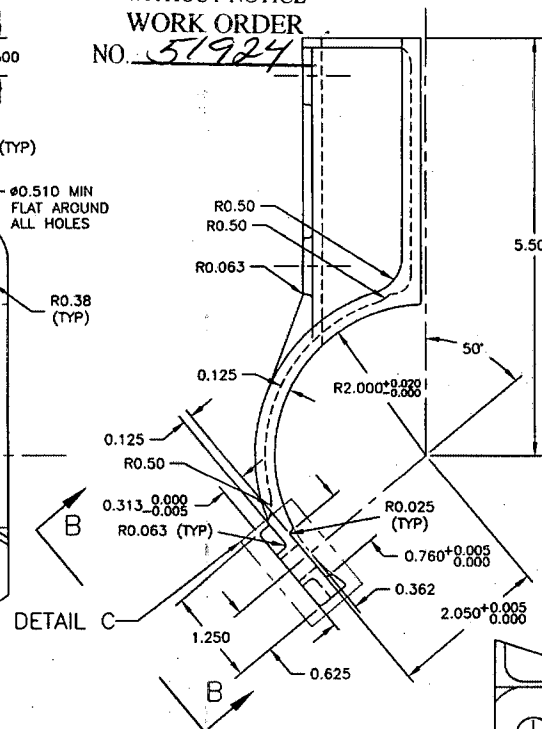
05.12.06

NOTES

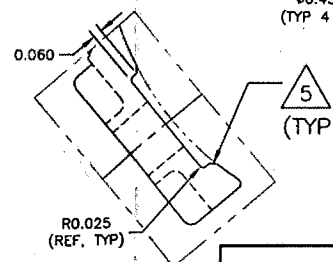
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

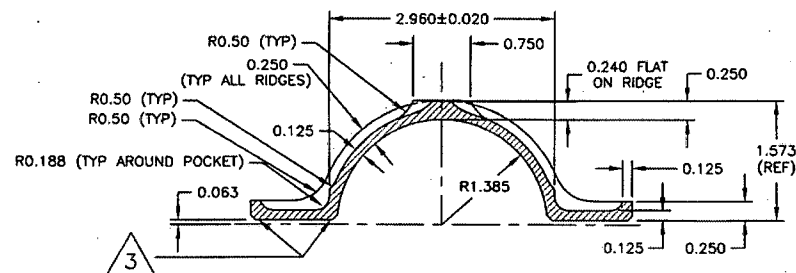
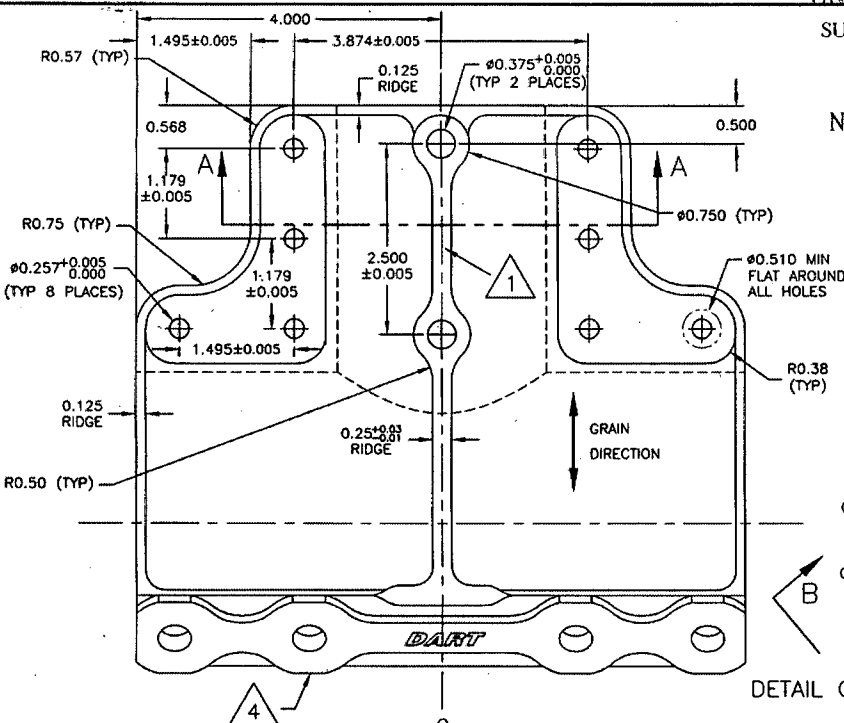
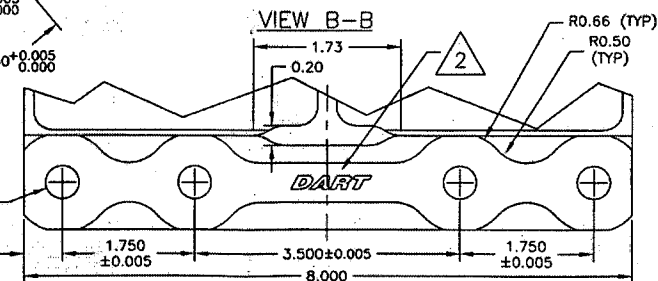
E



DETAIL C



DETAIL C  
SCALE 4:3



SECTION A-A

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2571
		TITLE OUTER FWD SADDLE
		SCALE 2:3

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DART AEROSPACE LTD.

**DART**

DART AEROSPACE LTD.  
HAMPSHIRE, ONTARIO, CANADA

REV. E

SHEET 1 OF 1

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 51924
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.439	.439		
B	1.745	1.755		1.750	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.499	3.499		
D	1.745	1.755		1.750	1.749	1.749	1.749		
E	7.990	8.010		8.000	8.002	8.003	8.001		
F	0.490	0.510		.501	.503	.504	.505		
G	0.257	0.262		.258	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.498	.497	.498	.497		
J	1.174	1.184		1.179	1.180	1.180	1.180		
K	0.558	0.578		.564	.565	.566	.565		
L	1.174	1.184		1.179	1.180	1.180	1.180		
M	1.490	1.500		1.496	1.496	1.496	1.496		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.875		
P	0.115	0.135		.123	.125	.121	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.246	.251	.252	.249		
S	0.115	0.135		.125	.124	.130	.130		
T	0.178	0.198		.188	.188	.189	.188		
U	2.940	2.980		2.960	2.962	2.960	2.962		
V	0.230	0.250		.235	.243	.240	.239		
W	0.115	0.135		.128	.129	.126	.128		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.356	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.633	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.387	1.387	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.124		
AG	0.240	0.280		.255	.260	.260	.260		
AH	0.240	0.260		.246	.251	.252	.249		
AI	2.000	2.020		2.002	2.002	2.002	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>SP</i>	Audited by:
Date: 09/10/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>5924</i>	
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571	
<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	26	3	4	By	Date
A	0.438	0.443		.439	.439				
B	1.745	1.755		1.749	1.749				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.749	1.749				
E	7.990	8.010		8.002	8.002				
F	0.490	0.510		.504	.503				
G	0.257	0.262		.259	.259				
H	0.375	0.380		.377	.378				
I	0.490	0.510		.502	.501				
J	1.174	1.184		1.180	1.178				
K	0.558	0.578		.569	.568				
L	1.174	1.184		1.180	1.177				
M	1.490	1.500		1.496	1.494				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.123	.121				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.251	.248				
S	0.115	0.135		.133	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.962	2.960				
V	0.230	0.250		.239	.240				
W	0.115	0.135		.118	.118				
X	0.308	0.313		.312	.312				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.365	.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.635	.635				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250	.249				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.255				
AH	0.240	0.260		.249	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: <i>SP</i>
Date: <i>09/10/19</i> / <i>09/16/21</i>

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>